

Work Order ID 85970-1

June-19-12 11:58:34 AM

\*85970\*

Page 1

Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Assembly

Start Date: 19/06/2012 Start Qty: 4.00

Required Date: 03/07/2012 Req'd Qty: 4.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: M.L.J.

QC:

Date: 12/06/14 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject  
Qty Qty Number Insp.  
Stamp

Draw Nbr

Revision Nbr

D2341

Rev F

D2360

Rev D

100

\*100\*

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks: 12.65" Long

0.00

0.00

110

\*110\*

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio D2341 and Dwg D2341  
2-Deburr

0.00

0.00

12/07/20

12/07/25

PTO



# Work Order ID 85970

June-19-12 11:58:34 AM

\*85970\*

Page 2

Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Assembly

Start Date: 19/06/2012 Start Qty: 4.00

Required Date: 03/07/2012 Req'd Qty: 4.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

120

\*120\*

QC

Quality Control

Operation  
Description

QC2- Inspect parts off machine FAI/FAIB

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

PD 12/07/25

130

\*130\*

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

0.00 14 12/07/27

140

\*140\*

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

7 7/6 12-7-30





# Work Order ID 85970

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Page 3

Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Assembly

Start Date: 19/06/2012 Start Qty: 4.00

Required Date: 03/07/2012 Req'd Qty: 4.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

150

\*150\*

Powdercoat

Powder Coating

160

\*160\*

QC

Quality Control

170

\*170\*

Small Fab

Small Fab

Operation  
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Aum

Set Up/  
Run Hours

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11-45 0.00

3200 F

12-15

QC3- Inspect Part Finish

0.00

Memo

0.00

Small Fab

0.00

Memo

0.00

Assemble as per dwg D2360

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

7X

MZ  
12/07/30

7 ✓ f M u 102/30

1X

EP 12/07/30





# Work Order ID 85970

June-19-12 11:58:34 AM

\*85970\*

Accept

\*N900040100\*

Setup Start \*NS1\*  
Stop \*NS2\*

Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Assembly

Start Date: 19/06/2012 Start Qty: 4.00

Required Date: 03/07/2012 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Run Start \*NR1\*  
Stop \*NR2\*

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Sequence ID/  
Work Center ID

180

\*180\*

QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/  
Run Hours

0.00 Smb

12-8-01

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

DAS  
16  
9-03

12-8-01

6

Identify as per dwg & Stock Location:

0.00

0.00

Memo

190

\*190\*

Packaging

Packaging

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

200

\*200\*

QC

Quality Control

12/8/01

MLJ 12/08/01

12-08-1  
①





# Picklist Print

June-19-12 11:58:38 AM

Page 1

Work Order ID: 85970

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

\*85970\*

\*D2360\*

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev H 07.06.12 een 825 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6201		Manufactured	No			100	F	77.3800	1.054	4.437895			

\*D6201\*

"T" Extrusion

M121673

Location

Loc Qty

Loc Code

MAT004

2.04

57767

1.34

71208

0.7

MAT028

69

81421

49

83987

20

MAT28

6.34

77491

5.34

81421

1

AN526C1032R18

Purchased

No

170

Each

648.0000

1

4

\*AN526C1032R18\*

Screw

\*\*

Location

Loc Qty

Loc Code

FP002

93

4523

93

ST348

555

101458

36

108079

419

110099

100

AN960JD10

NAS1149D0363J Purchased

No

170

Each

0.0000

2

8

\*AN960JD10\*

Washer

\*\*

4 M12 1524 (8) (14x)

P0 12/07/20

8.876

8.876

GP 12/07/31

7.7

GP 12/07/31





# Picklist Print

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Page 2

Work Order ID: 85970

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

\*85970\*

\*D2360\*

AN960JD10L

NAS1149D0332J Purchased

No

\*AN960JD10L \*

Washer

D2002-015

\*D2002-015\*

Knob

Manufactured No

47 M121708 (54)

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

170 Each 0.0000 8 32

\*\*

170 Each 25.0000 2 8

\*\*

EP 12/07/31  
EP 12/07/31

Location

Loc Qty

Loc Code

Mezz

23

16177

23

ST002

2

83480

2

Manufactured No

170 Each 12.0000 1 4

\*\*

2  
EP 12/07/31

D2345

\*D2345\*

Lock Channel

Location

Loc Qty

Loc Code

ST011

12

70800

12

Manufactured No

170 Each 13.0000 2 8

\*\*

FX  
EP 12/07/31

D2366

\*D2366\*

Lock Handle

Location

Loc Qty

Loc Code

ST008

13

73333

13

Manufactured No

170 Each 16.0000 1 4

\*\*

13 B8635 (K)  
EP 12/07/31

D2367

\*D2367\*

Handle Knob

Location

Loc Qty

Loc Code

ST008

16

68883

4

83541

12

4  
3

June-19-12 11:58:38 AM

Shop Packet Print

Page 2





# Picklist Print

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Page 3

Work Order ID: 85970

\*85970\*

Parent Item: D2360

\*D2360\*

Parent Item Name: Litter Tie Down Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

D2372

Manufactured No

\*D2372\*

Quick Release

170 Each 18.0000 2 8

\*\*

Location

Loc Qty

Loc Code

ST

18

80274

2

80510

16

Manufactured No

170 Each 14.0000 1 4

\*\*

Location

Loc Qty

Loc Code

ST008

14

66118

4

81892

10

Manufactured No

170 Each 13.0000 1 4

\*\*

Location

Loc Qty

Loc Code

ST019

13

79477

13

170 Each 8.447.000 1 4

\*\*

Location

Loc Qty

Loc Code

ST319

8447

111477

8332

15541

115

Purchased No

MS20470AD3-4

\*MS20470AD3-4\*

Rivet,Universal Head

12/07/31

386928 (1.3x)

12/07/31

43

12/07/31

386000 (7x)

12/07/31

7

June-19-12 11:58:38 AM

Shop Packet Print

Page 3





# Picklist Print

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Page 4

Work Order ID: 85970

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

\*85970\*

\*D2360\*

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

MS210421.3

Purchased

No

\*MS210421.3\*

Nut

170

Each

1.693.000

3

12

\*\*

## Location

## Loc Qty

## Loc Code

ST300

1693

117885

32

119017

816

119075

138

121444

707

MS27039-1-13

Purchased

No

\*MS27039-1-13\*

Screw

170

Each

109.0000

1

4

\*\*

## Location

## Loc Qty

## Loc Code

ST291

109

110844

9

119736

100

MS27039-1-15

Purchased

No

\*MS27039-1-15\*

Screw

170

Each

31.0000

2

8

\*\*

## Location

## Loc Qty

## Loc Code

ST291

31

118574

2

119736

1

121243

28

NAS679A3W

Purchased

No

\*NAS679A3W\*

Nut

170

Each

202.0000

1

4

\*\*

## Location

## Loc Qty

## Loc Code

GA

15

1463

15

2409

187

June-19-12 11:58:38 AM

Shop Packet Print

Page 4





**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>CE</b>	APPROVED <b>H</b>	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

**RELEASED**

07 06 07

**PARTS LIST:**

QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

D

D  
D

STOP COPY  
RETURN TO  
ENGINEERING  
INCORPORATED COPY  
SUBMIT TO MANAGEMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85970 MJS  
12/06/14

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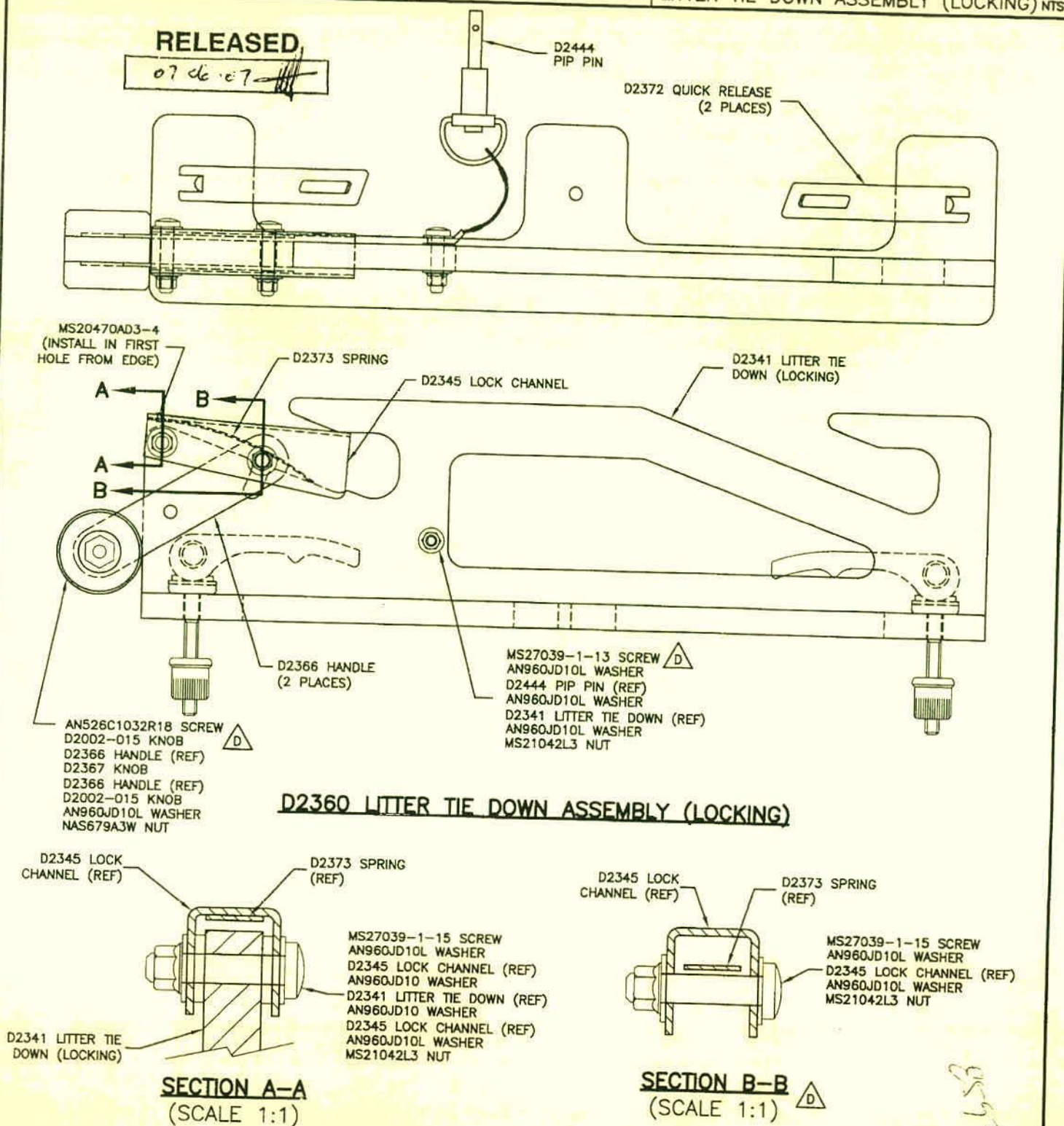
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**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <b>CE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D2360</b>
DATE <b>07.06.06</b>		REV. D SHEET 2 OF 2
		SCALE
		TITLE <b>LITTER TIE DOWN ASSEMBLY (LOCKING) NTS</b>



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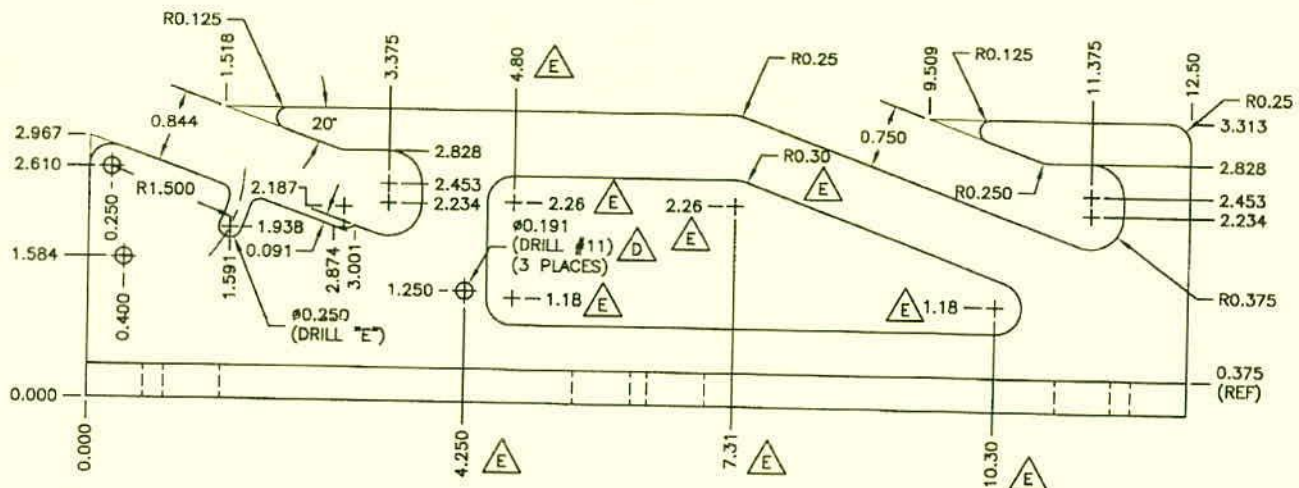
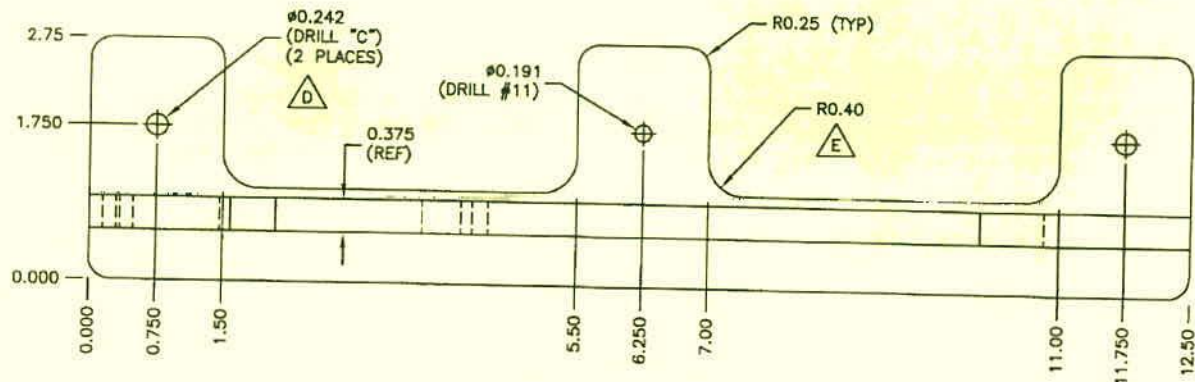






**DART**

DESIGN BW	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2341	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE	

**D2341 LITTER TIE DOWN BRACKET (LOCKING)**

- 1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION (6061-T6/T651 PER QQ-A-200/B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT PERMANENT INK MARKER

**RELEASED**

07-6-22

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61190/21

NO. 05760425  
WORK ORDER  
SUBJECT TO AMENDMENT  
UNCONTROLLED  
ENGINEERING  
RETURN TO  
SHOP COPY





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	85970
<b>Description:</b> Litter Tie Down Bracket (Locking)		<b>Part Number:</b>	D2341
<b>Inspection Dwg:</b> D2341 <b>Rev:</b> F		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.750	✓		VERO	PHD 01
2.75	+/-0.030	2.760	✓		"	"
Ø0.242	+0.005/-0.001	0.242	✓		"	"
Ø0.191	+0.005/-0.001	0.191	✓		"	"
R0.25	+/-0.030	0.250	✓		R.C.	
R0.40	+/-0.030	0.400	✓		R.C.	
12.50	+/-0.030	12.500	✓		M.7AB	PHD 11
11.750	+/-0.010	11.750	✓		VERN	CNC-02
11.00	+/-0.030	11.000	✓		"	PHD 01
7.00	+/-0.030	7.002	✓		"	CNC-02
6.250	+/-0.010	6.251	✓		"	"
5.50	+/-0.030	5.499	✓		"	PHD-01
1.50	+/-0.030	1.504	✓		"	"
0.750	+/-0.010	0.755	✓		"	"
0.400	+/-0.010	0.399	✓		"	"
1.584	+/-0.010	1.590	✓		"	"
2.610	+/-0.010	2.611	✓		"	"
0.250	+/-0.010	0.250	✓		"	"
0.844	+/-0.010	0.842	✓		"	"
Ø0.250	+/-0.010	0.250	✓		"	"
0.750	+/-0.010	0.751	✓		"	"
3.313	+/-0.010	3.312	✓		"	"
4.250	+/-0.010	4.249	✓		"	"
1.250	+/-0.010	1.249	✓		"	"

<b>Measured by:</b> 80	<b>Audited by:</b> DAS 14 9-88	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12/07/25	<b>Date:</b> 12/07/27	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue      P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	

